

Work Order ID 72508

Wednesday, July 27, 2011 11:47:39 AM

Page 1

Item ID: D3564-1

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 7/27/2011

Start Qty: 12.00

Required Date: 8/2/2011

Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev. 1 Prog
Rev: 1 2-Debur if necessary

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

120

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

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Setup Start

Stop

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Required Date: 8/2/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8179 and DT 8155 Form Joggles (2) as per Dwg D3564 on brake using Jig DT 8157

0.00

0.00

SB 11/28/02 (12)

140



QC

Quality Control

QC'S- Inspect part completeness to step on W/O

Memo

Ensure joggle as per dwg D3429

0.00

0.00

8/2/02

(12)

150



Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch A/R 2059B Hardcoat
m/18/96 Weld hardcoat as per Dwg D3437

0.00

0.00

x 10

11-04-08

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Item ID: D3564-1

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Setup Start



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Item Name: Wearshoe

Stop



Start Date: 7/27/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

Suloslos

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Suloslos



180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

N 117338

START TIME:

7:15 AM

OVEN TEMPERATURE:

7:15 AM FINISH TIME:

320 F

X 10 of Suloslos

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Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 7/27/2011 Start Qty: 12.00



Required Date: 8/2/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10X & M-L 11/08/09

200

Identify as per dwg & Stock Location: FP-K

0.00



Packaging

Memo

0.00

Packaging

10X & M-L 11/08/09

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/09
11-08-9
GD

Picklist Print

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Page 1

Work Order ID: 72508



Parent Item: D3564-I



Parent Item Name: Wearshoe

Start Date: 7/27/2011

Required Date: 8/2/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	212.0000	1.41	17.81053			

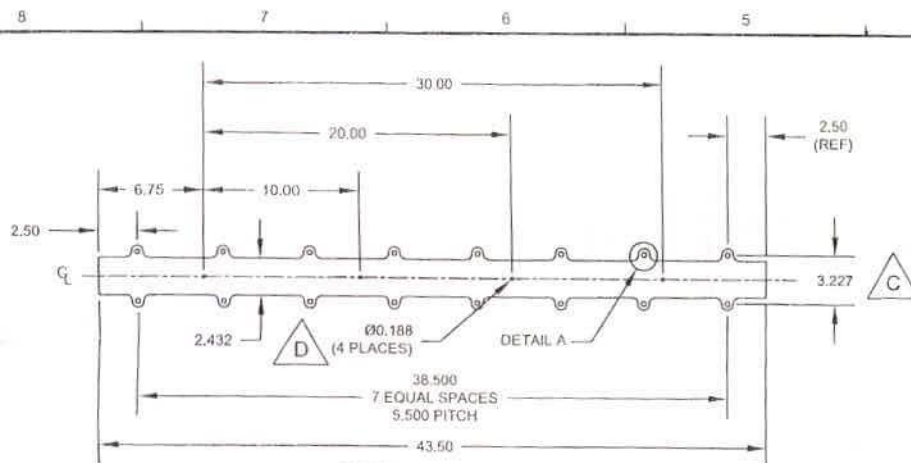


304/316 Sheet .063

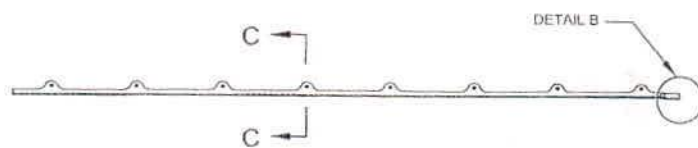


Location	Loc Qty	Loc Code
MAT020	19.4	
117275	1.7	
117653	17.7	
MAT021	192.6	
118217	192.6	

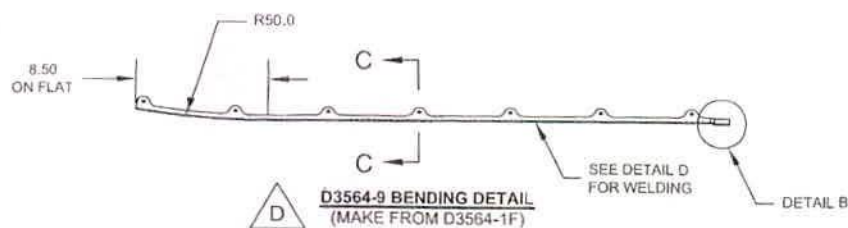
 18 8/11/2011/28



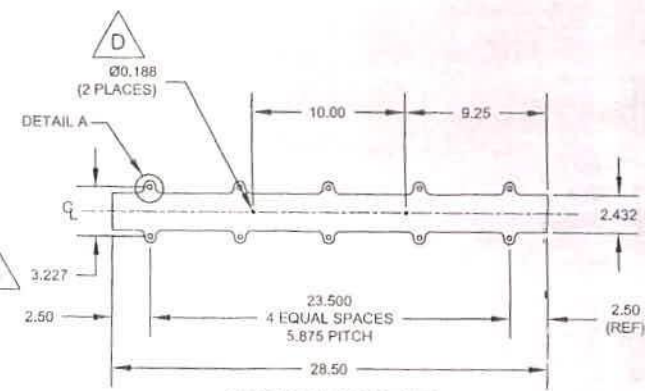
D3564-5F FLAT PATTERN



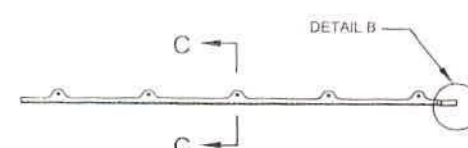
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



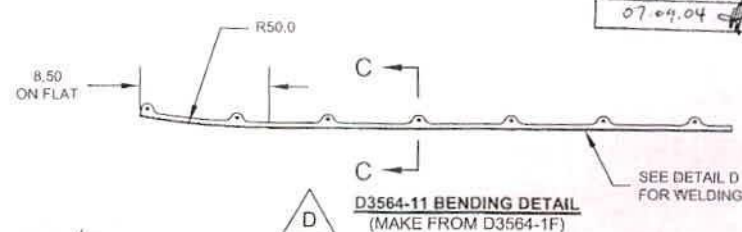
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



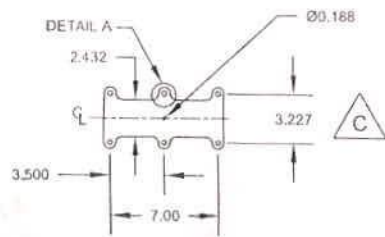
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

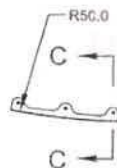
07-09-04

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MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:
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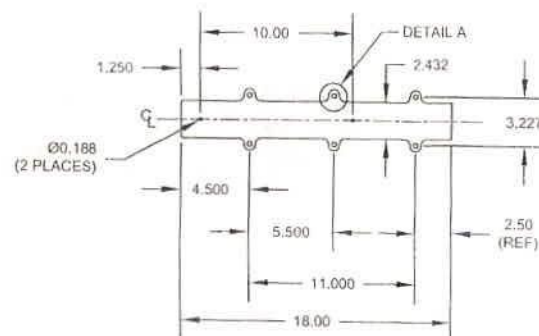
70508



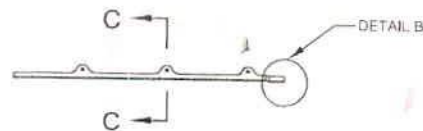
D3564-13F FLAT PATTERN



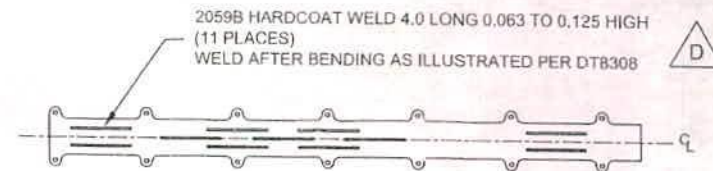
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



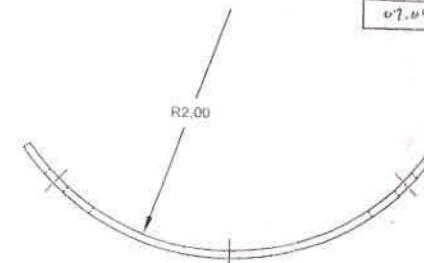
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



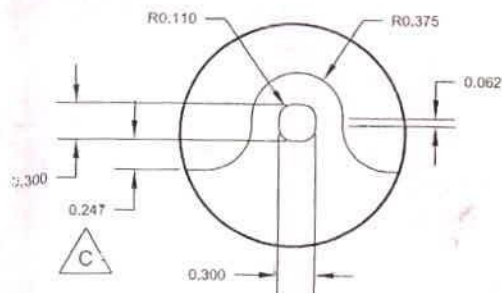
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED

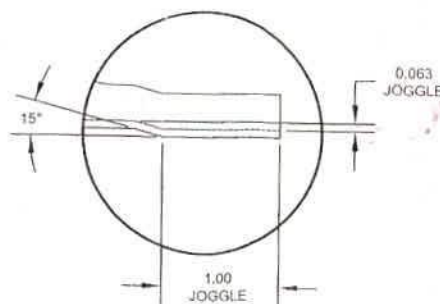
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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CHECKED	PH	DRAWING NO.	REV. D
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APPROVED	PH	TITLE	SCALE
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